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D119-796-151
Job Sheet 183799



Part No: D119-796-151

Job Qty: 1 ea

Part Name: Fwd Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D119-796-151 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP
REV:D 15-02-11 AS PER REV D JLM VERIFIED BY:DD IPP REV:E 17.12.11 REMOVE PICK KIT DD
VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/31/18	0.00	0.00	Start Up Crosstubes-1		AR 19-1-27
130	Crosstubes	1 pcs		10/31/18	0.00	0.49	Crosstubes-1		AR 19-1-27
140	QC	1 pcs		10/31/18	0.00	0.00	QC5		38
145	DC	1 pcs		10/31/18	0.00	0.00	DC		AR
150	Packaging	1 pcs		10/31/18	0.00	0.00	Packaging3-1	LG050	AR 19-1-27
160	QC21-FG	1 Ea		10/31/18	0.00	0.00	QC21		21 JAN 28 2019

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-151 ***Torque all clamps to 50 IN-LBS max.***
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***
145 - Photocopy bluefile and create labels as per PPP D119-796-151 chg 005
150 - Identify and pack for shipping as per PPP D119-796-151

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-141	Fwd Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-041	Fwd Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-22	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D119-796-141 187275	① 5136214	3	0
	D5123-3 5079324	④ 5079324	289	0
	D5149-041 5126767①	② 5109941	9	0
	MS21920-22 5083555	④ 5083555	107	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

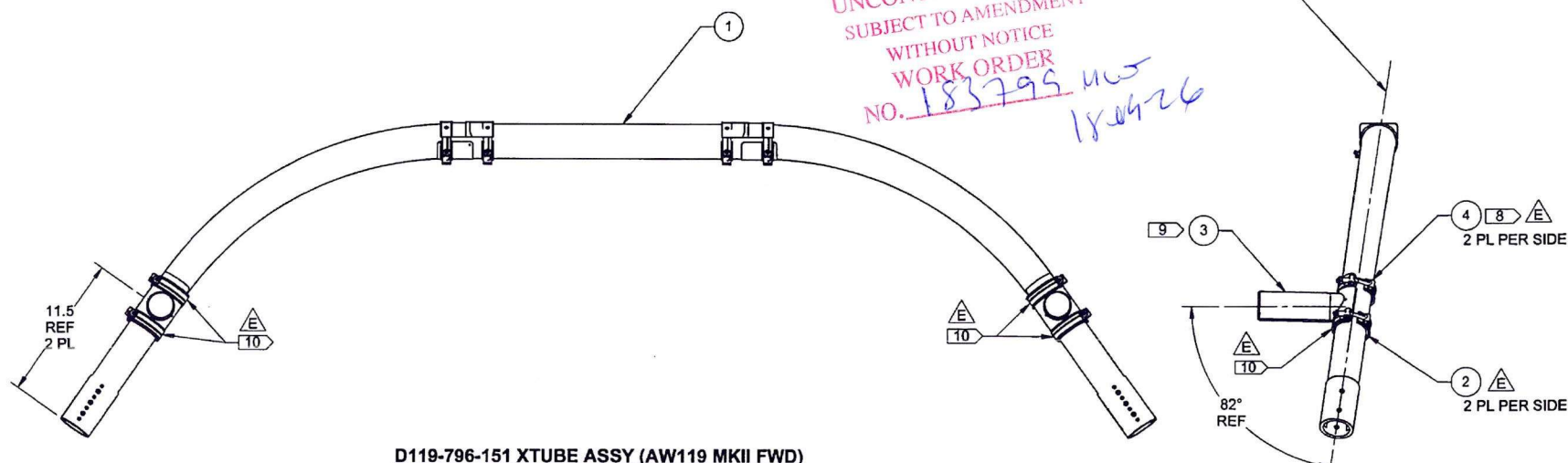
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval			
1270 Aberdeen Street Newkensbury, ON K64 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S148302 Part: D119-796-151 Job No: 183799 Serial No/Batch: S148302 Revision: E/F Inspector: _____ Exp Date: _____ Instructions: TC STC SH14-45 - Issue #1, EASA, STC SR03504NY 15/01/28, EASA						Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____			
Environm _____ De _____ Doc/I _____ Equip/Toc _____ Handling _____ Mate _____		Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		EGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		OTHER : _____							

ITEM	QTY	P/N	DESCRIPTION
	151		
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183795
180426



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 20.01 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN. THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

RELEASED
2017-05-04
ECN 17-538

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10 (PAR16-527) UPDATE WEIGHT DUE TO -141 CHANGE	ML	17.02.10
D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-151 TITLE XTUBE ASSY (AW119 MKII FWD) SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS	DATE 17.02.10	

APPROVED

A